

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82743

Thursday, April 05, 2012 1:02:49 PM

82743

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Item ID: D3698-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support Angle
 Start Date: 4/5/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 4/13/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00				6	0		FF 12-06-25
Brake NC	Memo 1-Bend 105 deg. angle as per Dwg D36982-form curve as per dwg D3698 and verify using template DT9001	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				6			W 12-06-25
Quality Control	Memo	0.00							
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				6			MG 12-6-25
Hand Finishing	Memo	0.00							

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: 247A ^{GA}	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
 12/6/26 SF
 12-6-26
 12/6/26
 12-06-26

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Picklist Print

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Work Order ID: 82743

82743

Parent Item: D3698-1

D3698-1

Parent Item Name: Support Angle

Start Date: 4/5/2012

Required Date: 4/13/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
 IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
 IPP rev:C 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	307.0560	0.4476	2.826947			

M6061T6S 032

6061-T6 Sheet 0.032"

**

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT021	307.056	
118106	48.606	
120218	33.77	
120285	43.68	
121099	181	

121099

6

12-4-11

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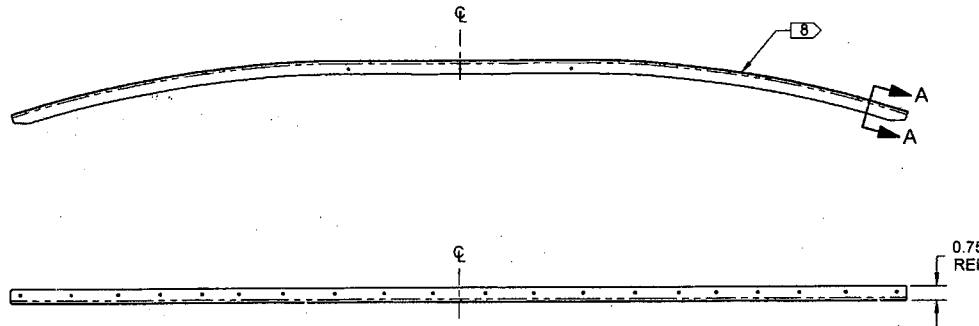
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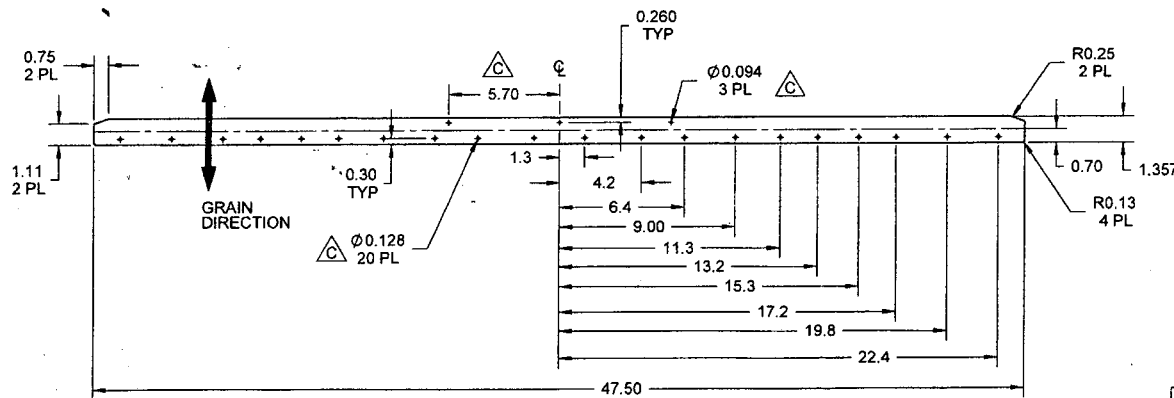
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82743

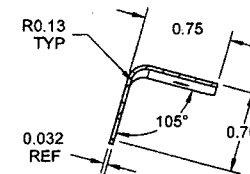
1012-04-3



D3698-1 SUPPORT ANGLE
(MAKE FROM D3698-1F FLAT PATTERN)



D3698-1F FLAT PATTERN



SECTION A-A

RELEASED
07-07-16

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK
REF. DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.20 lbs
- 8) FORM AS PER TEMPLATE DT9001

C	ZONE B5 Ø0.094 HOLE QTY WAS 29 PL. ZONE B6 ADDED "Ø0.128, 20 PL". ZONE B6 5.70 DIMENSION WAS REF.	AJS	08.09.08
B	REMOVE POWDER COAT. ZONE A.8	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3698	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT ANGLE	NTS
DATE	08.09.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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